



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3296-3
Job Sheet 176206



Part No: D3296-3

Job Qty: 8 ea

Part Name: Door Panel



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/18/18

Job Tracking No:

Due Date: 5/7/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP C 05.10.14 Added step 14 KJ/EC IPP Rev:E Now on Waterjet 06-11-02 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sig-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea		5/5/18	0.00	0.00	Start Up Waterjet		SC 8/24/20
100	Waterjet	8 pcs		5/5/18	0.04	0.64	Waterjet1		SC 8/24/20
120	QC	8 pcs		5/5/18	0.00	0.00	QC8		38
130	Small Fab	8 pcs		5/5/18	0.00	0.00	Small Fab-3		3-89
140	HandFinish	8 pcs		5/7/18	0.00	0.43	HandFinish1		SA 18-04-25
150	QC	8 pcs		5/7/18	0.00	0.00	QC7-2		11 APR 25 2018
160	Packaging	8 pcs		5/7/18	0.00	0.00	Packaging3	494	9-89 APR 27 2018
170	QC21-SA	8 Ea		5/7/18	0.00	0.00	QC21		9-89 APR 27 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.063	2024-T3 .063 Sheet	5.2256 sf (.6532 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M2024T3S.063	5	125	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Door Panel	5.030inches $\pm$ 0.030	5.060 5.000	5,038	
2	Door Panel	0.060inches $\pm$ 0.010	0.070 0.050	0,060	
3	Door Panel	0.128inches + 0.005 - 0.000	0.133 0.128	0,128	
4	Door Panel	17.000inches $\pm$ 0.030	17.030 16.970	17,000	
5	Door Panel	16.400inches $\pm$ 0.005	16.405 16.395	16,400	
6	Door Panel	0.300inches $\pm$ 0.010	0.310 0.290	0,299	
7	Door Panel	0.300inches $\pm$ 0.010	0.310 0.290	0,295	

8	Door Panel	1.000inches + 0.030 - 0.010	1.030 0.990	1.001
9	Door Panel	0.063inches ± 0.010	0.073 0.053	0.062

Plex 4/18/18 1:19 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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